

Date: Thursday, 11/29/2007 11:06:55 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 36040-2
 Estimate Number : 12712
 P.O. Number : N/A
 This Issue : 11/29/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 35696
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A New Issue 07-02-14 JLM

Drawing Name : WEARPAD
 Drawing Number : 08/01/02
 Part Number : D35371
 Project Number : D3537 REV C
 Drawing Revision : N/A
 Material : C
 Due Date : 12/10/2007

Qty: 100 Um: Each
 38

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	M304S16GA	304/316 .063 Sheet
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8.5104



Comment: Qty.: 0.0788 sf(s)/Unit Total : 7.8750 sf(s)

M304S16GA .063" 304 SS SHEET

Batch: 105997 RB 07-12-6

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3537

Dwg Rev: C

Prog Rev: C

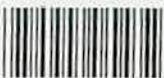
RB 07-12-6

108

2-Deburr if necessary

RB 07-12-6

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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RB 07-12-6

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

5.0 9/12/06 (+108)

5.0	BRAKE NC	NC BRAKE
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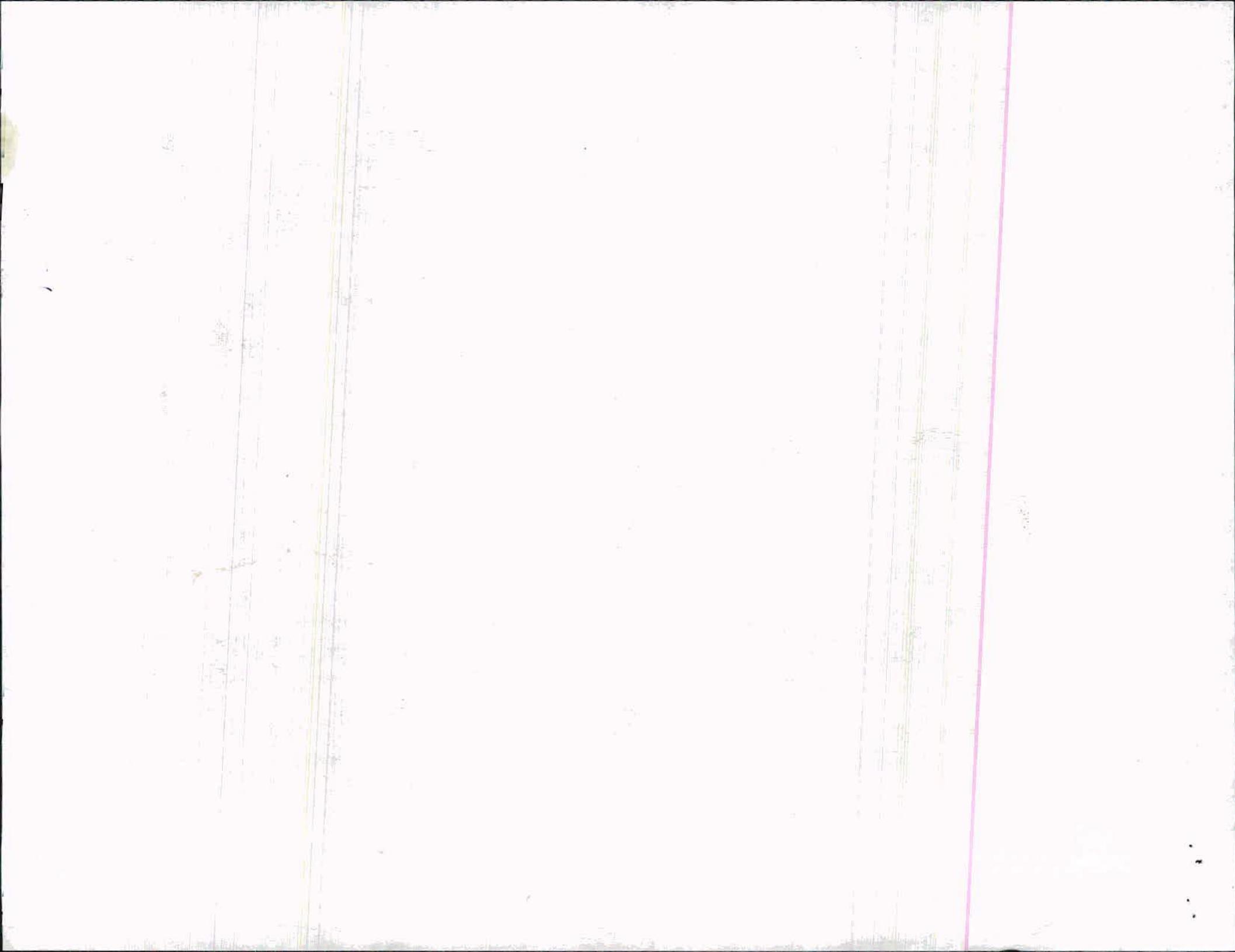


Comment: NC BRAKE

1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.

2-Identify as D3537-1

07/12/11



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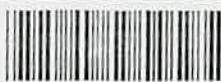
Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 36040

Part Number: D35371

Job Number:



Seq. #: Machine Or Operation: Description:

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch
A/R 2059B Hardcoat M106390/ M105959

1-Weld as per Dwg D3537 using Jig DT 8210

2-Remove any weld that penetrated through Wearpadif necessary

MF 08/01/08 20x
MF 08/01/02 38

7.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

MF 08/01/02

38

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MF 08/01/02

38

9.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M105642 BL 08-01-08 20

MF 08/01/02 38

10.0 QC3 INSPECT POWDER COAT/ CHEMICAL CONVERSION

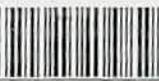


M.F 08/01/08(20x)

Comment: INSPECT POWDER COAT/ CHEMICAL CONVERSION

08-01-02 38

11.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-20

FP-20 M.F

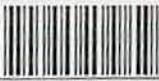
08/01/08(20x)

HS

08-01-02

38

12.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

MF 08/01/03 20

MF 08/01/09

Job Completion



MF 2008/1/2 38x

MF 2008/1/8 20x

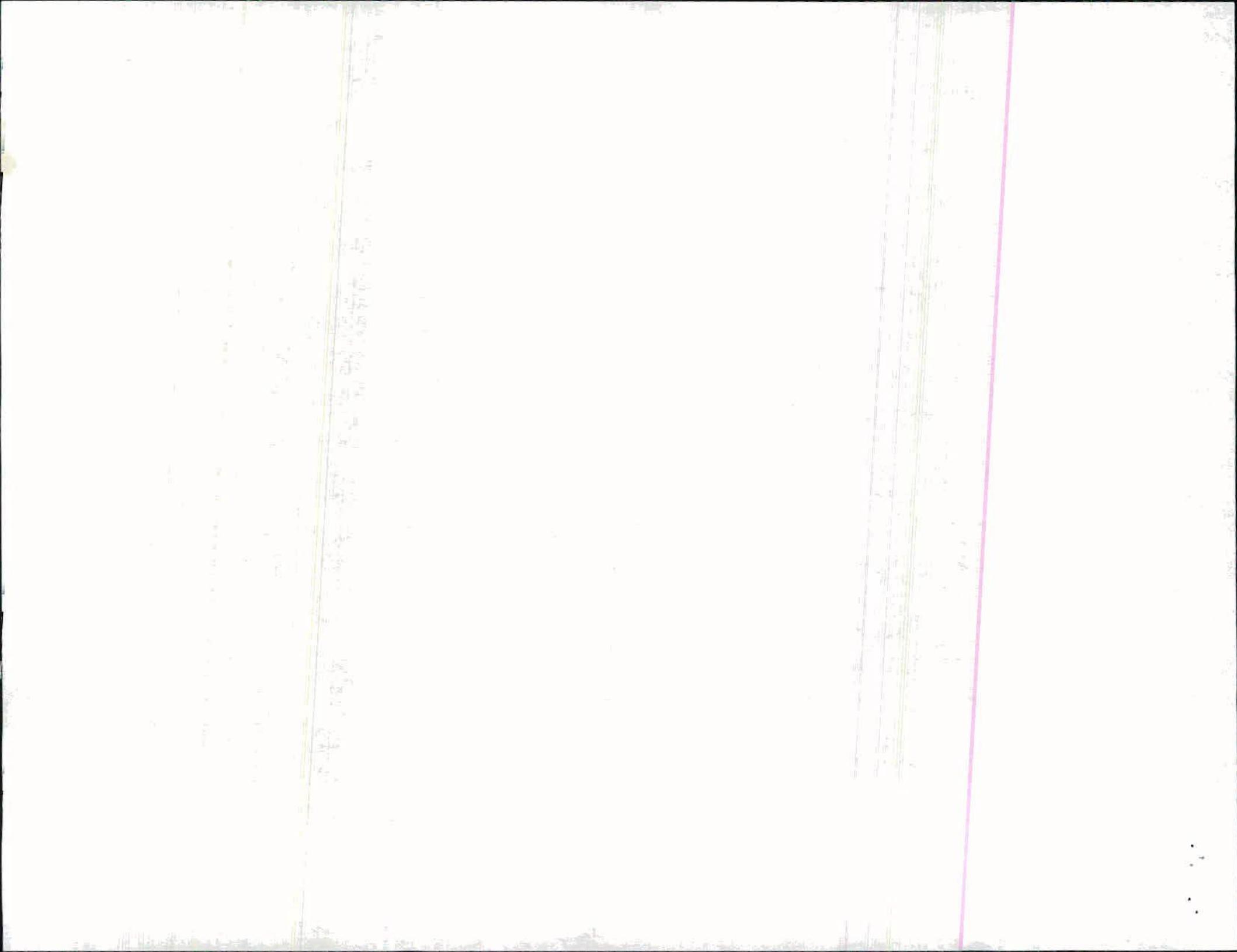
100
Rancho
M. 1000

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
08/01/02	#9.0	w/o was split for 38 pcs	✓	08/01/02	x38		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/02	#9.0	6 parts have a dim. of 3.600 instead of 3.625 P.C. water jet cut too small.	✓ 07.12.05 pcc 05.04.02	Parts are acceptable this is fine only. Acceptable edge distance remains based on E/D-1.5	✓ 07-17-04	✓ 07/12/02	✓ 07.12.05 pcc 05.04.02	✓ 07/12/02



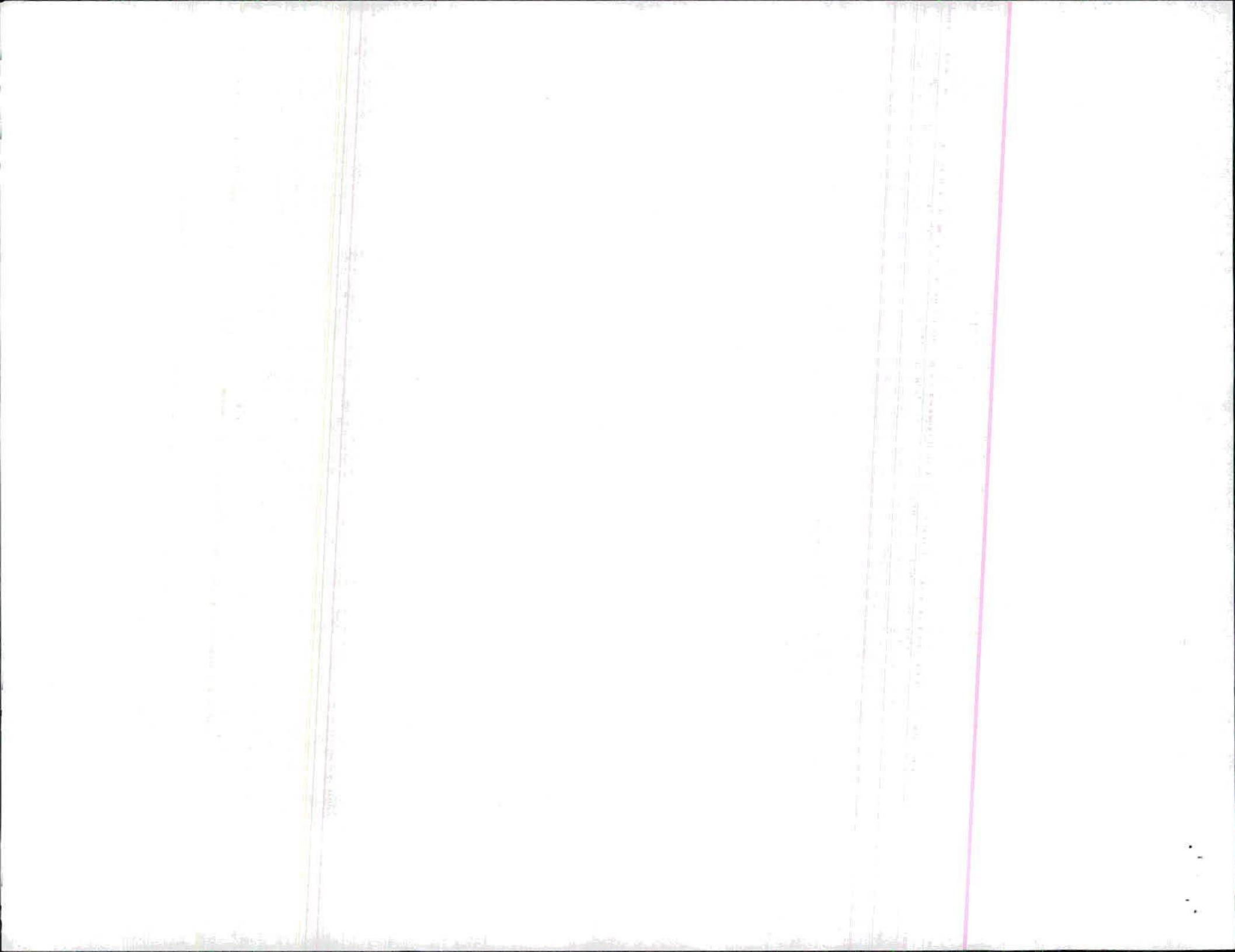
DART AEROSPACE LTD	Work Order:	36040
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

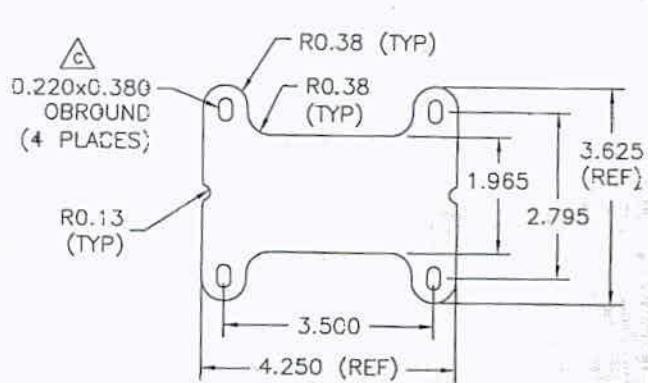
X First Article Prototype

Measured by: <u>DB</u>	Audited by: <u>6</u>	Prototype Approval: N/A
Date: <u>07-12-6</u>	Date: <u>7/7/06</u>	Date: N/A

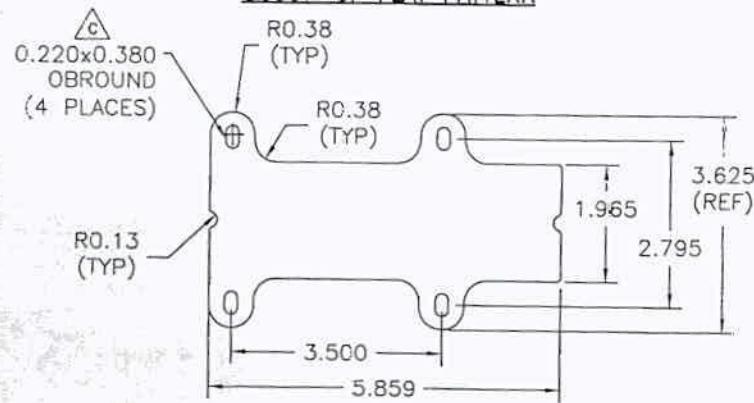
Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	<i>[Signature]</i>



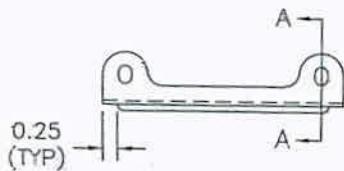
D3537-1F FLAT PATTERN



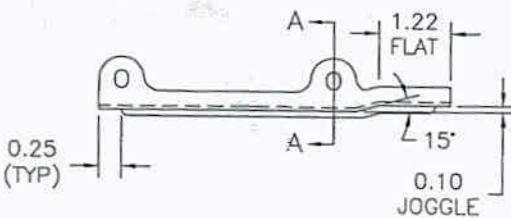
D3537-3F FLAT PATTERN



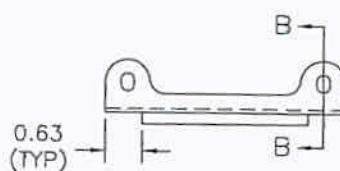
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)

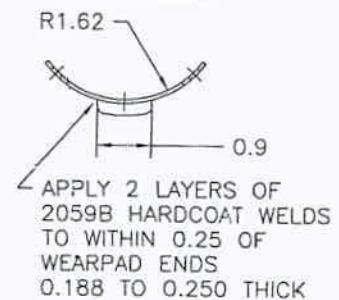


D3537-1/-3/-5/-7 WEARPAD NOTES

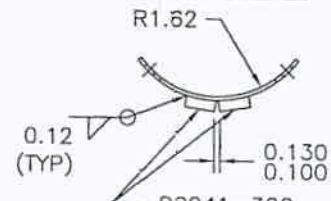
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

NO. 36C
WORK OF
SUBDIVISION
SUBJECT TO AN
ENGINEER
RETRAIT
SHOP COR.
WITH COTLN

SECTION A-A



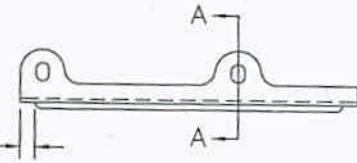
SECTION B-B



D2941-300
REMOVE POWDER COAT FROM THESE SURFACES

RELEASED
07.05.08 A4
per ECN

D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



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DART AEROSPACE USA, INC.

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537
DATE	TITLE	REV. C SHEET 1 OF 1
07.04.13	WEARPAD	SCALE 1:2

